

Date: Friday, 03/04/2009 7:35:35 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ANGLE EXTRUSION
Job Number :	46909		
Estimate Number :	10050		
P.O. Number :		Part Number :	D6207
This Issue :	03/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D6207 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	41418	Drawing Revision :	A
Written By :	<u>[Signature]</u>	Material :	
Checked & Approved By :	<u>CLO9/04/03</u>	Due Date :	10/04/2009
Comment :	Est. A: 02.03.15 New Issue NG	Qty:	<u>60</u> Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8535CLO9/04/08

a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125"

b) Material: 6061-T6/T6511 (QQ-A-200/8)

c) Minimum ultimate tensile strenght = 38 ksi

d) Minimum yield tensile strenght = 35 ksi

(60)

2.0	D6207P	Angle Extrusion 1x1x.125
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Comment: Qty.: 1.0000 f(s)/Unit Total : 60 0.0000 f(s)

Angle Extrusion 1x1x.125

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

P 09/04/16(60)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6207

Check hardness with Webster tester

5 09/04/17 x 3 Lengths

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 09/04/16(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE EXTRUSION

Job Number: 46909

Part Number: D6207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

AD 09/04/20

Job Completion



U 09.04.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

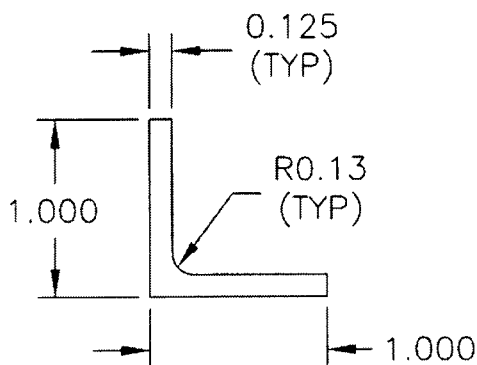
NOTE: Date & initial all entries



DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING



W/O: 46909
C/L 09104/03

D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

Purchase Order

Date Apr 08, 2009	Page 1
Purchase Order Number PO00008535	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
069048

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Apr 08, 2009	N30	yours	Apr 16, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 60.0000	D6207P	Angle Extrusion 1x1x.125 Comments: AS PER DWG D6207 REV. A ANGLE EXTRUSION: 1" X 1" X .125" MATERIAL: 6061-T6 OR 6511 (QQ-A-200/8) MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM YIELD TENSILE STRENGTH = 35 KSI B46909	16/04/2009	No	0.650000	f	39.00
24.0000	M4140NB0625X0400	4140 Steel Bar .625 x 4.00 Comments: MATERIAL: 4140 AS PER CF LP ANN BAR PER ASTM A 331 / A 108	16/04/2009	No	29.166666	f	700.00
100.0000	M304TR0675W091	304 RD Tube .675 x .091 Comments: MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING OR SCHEDULE 40 SEAMLESS	16/04/2009	No	6.750000	f	675.00
20.0000	M6061T6B2000X040	6061T6 Bar 2.00 x 4.00 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115 4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	16/04/2009	No	20.100000	f	402.00
12.0000	M7075T6B1500X150	7075 T6 BAR 1.500 x 1.5 Comments: MATERIAL: 7075-T6 OR T651/T6510/T6511/T62 ALUMINUM BAR PER AMS-QQ-A-225/9 OR AMS 4122/4123/4186/4187 OR PER AMS-QQ-A-200/11	16/04/2009	No	16.250000	f	195.00
24.0000	M7075T73R1000	7075-T73 Rd Bar 1.00 Comments: MATERIAL: 7075-T6 OR T651/T6510/T6511/T652 OR T62 ROUND BAR PER AMS-QQ-A-225/9 OR AMS 4122	16/04/2009	No	9.166666	f	220.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Continued on next page...

Material Test Report

Customer Ship To:

Magna Stainless Inc.
5775 Kieran St.

St-Laurent
QB H4S 0A3

Our Order: 358672 - 1

Your PO # PO02280

Part # 05666-000-240

Die: ES05666

Description: 1.000 x 1000 x .125

Alloy Temper 6061 T6

Print Date: 12/23/2008

Chemical Properties

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others each	others total	Al
0.40-0.8	0.7 max	0.15-.40	0.15 max	0.8-1.2	0.04-0.35	0.25 max	0.15	0.05	0.15	remain

Mechanical Properties

Strength ksi

Test ID	Test Date	CastNum	Ultimate	Yield (2% Offset)	Elongation (2" gage length)
115262	12/23/08	5850	43.05	39.27	8.2

Sorbelle

Applicable Specifications: ASTM B221-06 ASTM B308-02 ASTM B429 QQA200/8 QQA200/16

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Doug Barnes - Tensile Testing

Authorized

Evan Eng
Evan Eng, Quality Assurance Mgr.

PANASIA ALUMINIUM (CHINA) LIMITED
Aluminium Mill Certificate

Cert. No.: PAAV-MC0808005

CUSTOMER: **ASA Alloys Inc**

PO No. **072216-BB**

Contract No.: **NIL**

Alloy & Temper: **6061-T6511**

Standards: **ASTM-B221**

QQA-200/8

Container No: **ZCSU9009360**

Date of shipment: **2008.08.08**

66743
66744
66745
66750
66751
66752

Chemical Composition (%)									
Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Al
Standard	0.40-0.80	0.80-1.20	0.7max	0.15-0.40	0.15max	0.25max	0.04-0.35	0.15max	Rem.
20080723201	0.673	0.871	0.256	0.193	0.038	0.035	0.095	0.019	Rem.
20080725301	0.671	0.872	0.254	0.186	0.037	0.031	0.091	0.017	Rem.
20080726301	0.675	0.863	0.253	0.194	0.034	0.033	0.092	0.016	Rem.
20080724302	0.672	0.869	0.258	0.197	0.035	0.034	0.094	0.010	Rem.
20080724401	0.670	0.864	0.259	0.192	0.033	0.032	0.093	0.012	Rem.
20080711302	0.677	0.870	0.252	0.196	0.036	0.030	0.096	0.018	Rem.

Tensile Test Result					
Heat No.	Die No.	Customer part No.	Description	Tensile Strength	
				N/mm ² 280 min	Ksi 38 min
20080723201	T10008		✓ 1 x 0.095 Sq Tube Sq. Corner	295	43
20080725301	F10000044		✓ 3/8 x 3 Flat bar Sharp Corner	295	43
20080726301	F10030		✓ 1 x 3 Flat bar Sharp Corner	285	42
20080724302	F10000087		✓ 2 x 4 Flat bar Sharp Corner	290	42
20080724401	T10039		✓ 3/4 x 120 Sq Tube Sq. Corner	290	42
20080711302	T10026		✓ 1 x 0.125 Sq Tube Sq. Corner	285	42

Hardness Test Result			
Section No.	HRE	Webster	Other Remarks
T10008	91	15.5	
F10000044	91	15.6	
F10030	90	15.3	
F10000087	90	15.3	
T10039	92	15.9	
T10026	92	15.9	

The above result was done on testing samples and the mill shall guarantee the same quality for the same batch of products. It is certified that this material conforms in all respects to the requirements of the above standards latest revision.

QC: Xiaotuan Zhang

Checked By: Junxian Luo

